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RBEL135M-2905-101-00

Job Sheet 186073



9026

Part No: RBEL135M-2905-101-00

Job Qty: 2 ea

Part Name: Hydraulic Pump Drive Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL135M-2905-101 REV 9 IPP REV A 18.05.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/28/18	0.00	0.00	Start Up Small Fab-2		MCL
110	Small Fab	2 pcs		12/28/18	0.00	2.00	Small Fab-3		MCL
120	QC	2 pcs		12/28/18	0.00	0.00	QC5		MCL
130	Packaging	2 pcs		12/28/18	0.00	0.00	Packaging3-1		MCL
140	QC21-FG	2 Ea		12/28/18	0.00	0.00	QC21		MCL

Part Op
Descriptions: 110 - 1-Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEL135M-2905-101-01	Case	2 Ea (1 ea)	90-Start up Operation	5143285
5972K289	Bearing	4 Ea (2 ea)	110-Small Fab	5142224
5N16DD1	Threaded Knob	4 Ea (2 ea)	110-Small Fab	5128742
6117-33	Small Angle Grinder Motor	2 Ea (1 ea)	110-Small Fab	5126510
90967A210	External Snap Ring Ø17mm	2 Ea (1 ea)	110-Small Fab	5118214
91166A250	Flat Washer ØM6	26 Ea (13 ea)	110-Small Fab	51138414-10
91166A270	Washer, M8	2 Ea (1 ea)	110-Small Fab	5077697
91280A322	Flat Head Machine Screw	20 Ea (10 ea)	110-Small Fab	5126983
91280A534	Hex Head Cap Screw	2 Ea (1 ea)	110-Small Fab	5124954
91292A441	Socket Head Cap Screw	6 Ea (3 ea)	110-Small Fab	5124958
91420A218	Flat Head Machine Screw	4 Ea (2 ea)	110-Small Fab	5124958
91420A220	Flat Head Machine Screw	4 Ea (2 ea)	110-Small Fab	5124846
91420A430	Flat Head Machine Screw	4 Ea (2 ea)	110-Small Fab	5124848
91585A010	Dowel Pin	4 Ea (2 ea)	110-Small Fab	5124957
AN960-1016	Flat Washer 5/8 X .063 thick NAS1149F1063P	2 Ea (1 ea)	110-Small Fab	5067037
RBEL135M-2905-101-03	Bottom Cover	2 Ea (1 ea)	110-Small Fab	5144530
RBEL135M-2905-101-05	Top Cover	2 Ea (1 ea)	110-Small Fab	5144529
RBEL135M-2905-101-07	Geared Pulley	2 Ea (1 ea)	110-Small Fab	5147705
RBEL135M-2905-101-09	Drive Pulley	2 Ea (1 ea)	110-Small Fab	5142235
RBEL135M-2905-101-11	Clamp Top	2 Ea (1 ea)	110-Small Fab	5142094
RBEL135M-2905-101-13	Motor Clamp	2 Ea (1 ea)	110-Small Fab	5142123
RBEL135M-2905-101-14	Collar	2 Ea (1 ea)	110-Small Fab	5142188
RBEL135M-2905-101-15	Clamp	2 Ea (1 ea)	110-Small Fab	5142121

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

RBEL135M-2905-101-17	Thumb Screw	2 Ea (1 ea)	110-Small Fab
RBEL135M-2905-101-19	Slide Guide	4 Ea (2 ea)	110-Small Fab
RBEL135M-2905-101-21	Slide	4 Ea (2 ea)	110-Small Fab
RBEL135M-2905-101-23	Pin	2 Ea (1 ea)	110-Small Fab
RBEL135M-2905-101-39	Poly-V Groove Belt	2 Ea (1 ea)	110-Small Fab
RBEL135M-2905-101-45	Arrow Emblem	2 Ea (1 ea)	110-Small Fab

5142050
5142104
5142175
5142629
5146000

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEL135M-2905-101-01	2	0	0
110-Small Fab	5972K289	4	6	0
	5N16DD1	4	0	0
	6117-33	2	0	0
	90967A210	2	10	0
	91166A250	26	96	0
	91166A270	2	200	0
	91280A322	20	0	0
	91280A534	2	100	0
	91292A441	6	50	0
	91420A218	4	100	0
	91420A220	4	100	0
	91420A430	4	100	0
	91585A010	4	100	0
	AN960-1016	2	0	0
	RBEL135M-2905-101-03	2	0	0
	RBEL135M-2905-101-05	2	0	0
	RBEL135M-2905-101-07	2	0	0
	RBEL135M-2905-101-09	2	0	0
	RBEL135M-2905-101-11	2	0	0
	RBEL135M-2905-101-13	2	0	0
	RBEL135M-2905-101-14	2	0	0
	RBEL135M-2905-101-15	2	0	0
	RBEL135M-2905-101-17	2	0	0
	RBEL135M-2905-101-19	4	0	0
	RBEL135M-2905-101-21	4	0	0
	RBEL135M-2905-101-23	2	0	0
	RBEL135M-2905-101-39	2	6	0
	RBEL135M-2905-101-45	2	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/18 11:42 AM Dart.lajeunesse.marie



Container No: S144981



Part: RBEL135M-2905-101-00

Job No: 186073

Serial No/Batch: S144981

Revision: 9

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/15/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

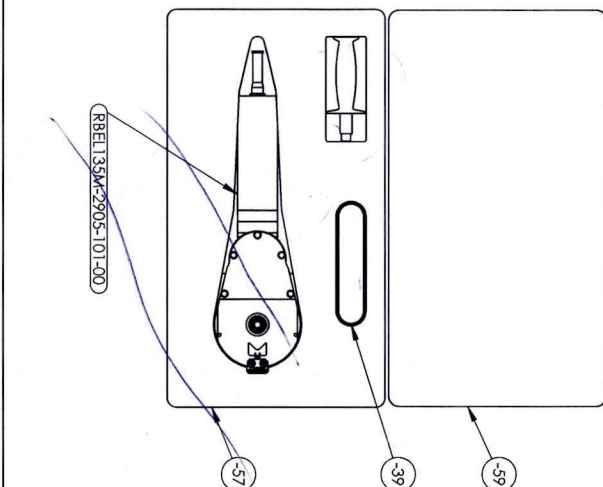
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

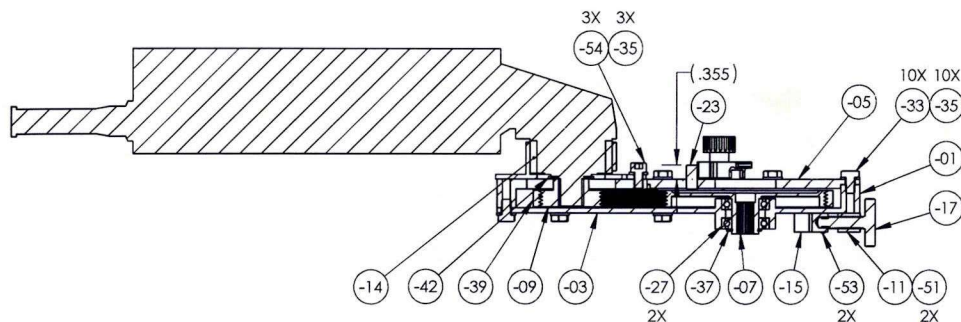
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REV	QTY	Part #	Unit	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.Q.
1	1	-40	1	HYDRAULIC PUMP DRIVE TOOL	6061		2
2	1	-41		CASE	6061		3
3	1	-43		BOTTOM COVER	6061		4
4	1	-43		TOP COVER	6061		5
5	1	-47		GEARED PULLEY	1018/1020 CR		6
6	1	-49		DRIVE PULLEY	6061		7
7	1	-11		CLAMP TOP	344/1018/1020 HR		8
8	1	-13		MOTOR CLAMP	6061		9
9	1	-14		COLLAR	6061		10
10	1	-15		CLAMP	6061		11
11	1	-17		THUMB SCREW	3.5.		12
12	2	-19		SLIDE GUIDE	1018/1020 CR		13
13	2	-21		SLIDE	1018/1020 CR		14
14	1	-23		PIV	303/304		15
15	2	-25		THREAD PUNCH	M5 X .08 X 1.0mm (L.W. WINCO #5N1421)		2
16	2	-27		BEARING	608SRU (MCMASTER-CARR #9722289)		2
17	2	-29		FLAT HEAD MACHINE SCREW	M4 X .07 X 10mm (MCMASTER-CARR #91420A20)		2
18	2	-31		FLAT HEAD MACHINE SCREW	M4 X .07 X 8mm (MCMASTER-CARR #91420A218)		2
19	10	-33		HEX HEAD CAP SCREW	M6 X 1 X 10mm (MCMASTER-CARR #91290A32)		2
20	13	-35		FLAT WASHER	96mm (MCMASTER-CARR #91164A20)		2
21	1	-37		EXTERNAL SNAP RING	S.S.		2
22	1	-39	1	POLY-V GROOVE BELT	18024 (MCMASTER-CARR #905674210)		2
23	1	-43		FLAT WASHER	STEEL		2
24	1	-45		SMALL ANGLE GRINDER MOTOR	050/8 X .003 THICK (MCMASTER-CARR #91420A10)		2
25	1	-47		ARROW BARREL	WINUL		16
26	1	-49		FLAT WASHER	STEEL		2
27	1	-51		FLAT HEAD MACHINE SCREW	96mm (MCMASTER-CARR #91164A20)		2
28	2	-53		DOVCEL PIN	S.S.		2
29	3	-54		SOCKET HEAD CAP SCREW	M6 X 1 X 12mm (MCMASTER-CARR #91290A41)		2
30	B/O	-55	1	CASE	PLASTIC		N/S
31	B/O	-57	1	BOTTOM TOOL CLAMP	ENHAFOM 220 BLACK		17
32	B/O	-59	1	TOP FOAM	2201 X 14.52 X 28.35 (CASE SOLUTIONS)		18
33	AST		1	DART PLACARD	ALUMINUM		N/S

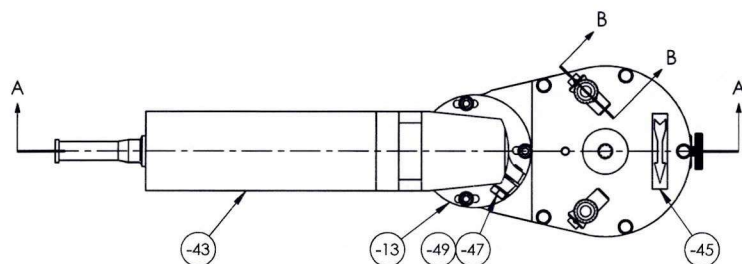


TITLE		DATE		SHEET 1 OF 18	
HYDRAULIC PUMP DRIVE TOOL		11/28/2016		9	
REV		DATE		BY	
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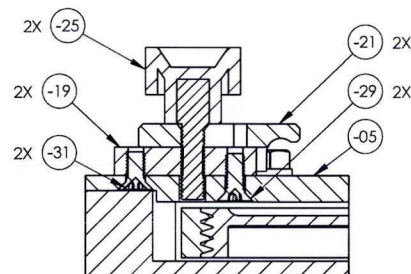
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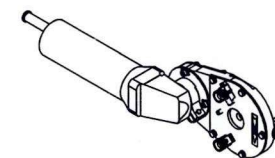
SECTION A-A
SCALE 1:3



HYDRAULIC PUMP DRIVE TOOL



SECTION B-B
SCALE 1:1



NOTES:
2. -13, -14, & -42 USED WITH GRINDER:
MILWAUKEE #6117-33

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED MOTORS FROM FLEX #L3309FR TO MILWAUKEE #6116-33, ALSO CHANGED PULLEY SIZE TO ADJUST FOR THE 1,000 RPM DIFFERENCE. DRIVER PULLEY -07 WAS Ø1.495 NOW Ø1.603, AND DRIVER 07 WAS Ø4.173 NOW Ø4.065. ALSO -07 Ø3.671 (X2) IS NOW Ø3.779 (X2).	5/12/2010	WP	DW
2		CHANGED -13 MOTOR CLAMP TO FIT NEW MOTOR & MOVED -01 CASE M6 HOLE UP .071 FROM B.C. Ø3.206. ALSO REPLACED (3) -33 HEX HEAD CAP SCREW WITH -54 SOCKET HEAD CAP SCREW.	9/14/2010	WP	DW
2A		ADDED OPTIONAL 2 UNIT KIT WITH HARD CASE, AND CHANGED FROM 5 PAGES TO 8.	9/16/2010	WP	
3		ADDED COMPARTMENT FOR HANDLES TO -101-43 PER D.W.	12/10/2010	RJC	RW
4		CH'D -05 QTY. FROM 1 TO 2, LABELED -01 SECTION C-C. CH'D -05 COUNTERSINK FROM Ø.276 TO Ø.310, CH'D -07 Ø.17mm TO Ø.6488 +.0005 - .0000, ADDED -07 (.414) DIM. CH'D -13 CUT REF. DIM. FROM .08 & .076 TO .093. ALL CHANGES PER G.E.	12/29/2010	RJC	RW
5		ADDED -00 ASSY. 2 EA. TO BOM. DOUBLED ALL BUYOUT QUANTITIES. DELETED RBEL135M2905-101-8. CH'D -05 DIM. FROM Ø.267 P.F. -23 TO LIMIT DIM. .2666 - .2660. ADDED -11 & -07 NICKLE PLATE THICKNESS .0004 - .0006. ADDED -19 NICKLE PLATE THICKNESS .0004 - .0006. CH'D -19 DIM. FROM .392 S.F. -21 TO LIMIT .3914 - .3905. ADDED -21 NICKLE PLATE THICKNESS .0004 - .0006. CH'D -21 DIM. FROM .393 S.F. -19 TO LIMIT DIM. .3944 - .3930. CH'D -23 DIM. FROM BASIC .267 TO Ø.2674 - .2670.	12/20/2012	RJC	SE
5A		-05 DELETED Ø.3.149. SEPERATED PARTS ONTO INDIVIDUAL PAGES.	2/26/2013	BIM	GE
6		ADDED PARTS -14 & -42 FOR USE WITH GRINDER MODEL MILWAUKEE #6117-33. ADDED NOTES 3 & 4 SHEET 1. ADDED NOTES 1 & 2 SHEET 2. REDRAWN WAS AUTO CAD IS SOLIDWORKS.	7/29/2013	CF5	DW
7		CH'D P/N WAS RBEL135M2905-101 IS RBEL135M-2905-101. -21 CH'D CORNER WAS NO RADIUS IS 2X R.13.	10/9/2013	CF5	GE
8		-17 CH'D DIMENSION WAS 5Ø.46 IS 5Ø.50. -17 CH'D DIMENSION WAS 1.181 IS 1.18.	6/16/2014	DJN	GE
9	16-0222	DELETED NOTE 1SHEET 2. CH'D HYDRAULIC PUMP DRIVE TOOL ASSY. TO -00 & CH'D QTY WAS 2 IS 1. -09 CH'D ASSY QTY. WAS 2 IS 1. ADDED QTY. 1 FOR SPARE. -41 DELETED. -43 CH'D B/O P/N WAS MILWAUKEE #6116-33 IS MILWAUKEE #6117-33. CH'D PLACARD WAS -41 RB41009 IS RB41011.	11/23/2016	RJC	SM

DART AEROSPACE																													
TITLE HYDRAULIC PUMP DRIVE TOOL																													
DWG NO. RBEL135M-2905-101-00	REV 9																												
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